

Date: Wednesday, 1/4/2006 2:37:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 25395C		
Estimate Number	: 10354		
P.O. Number	: N/A	Part Number	: D2322
This Issue	: 1/4/2006	Drawing Number	: D2322 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 25089C	Material	: N/A
		Due Date	: 1/25/2006
Written By	: <u>SEE COMMENT BELOW</u>	Qty:	<u>30</u> Um: Each
Checked & Approved By	: <u>SEE ABOVE USER</u>		
Comment	: Est Rev:A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: M19059

J.L 06.02.01 30

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500")

J.L 06.02.01 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2322, use stack of 15

J.L 06.02.01 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.01 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Eo 06/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *JD* Date: 06/02/01

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-01	3	- 10 parts are scrapped - .250 dimension $\pm .005$ ranges between .235 to .260	<i>JD</i> 06/02/01	destroy & replace	JL 06-02-01	<i>JD</i> 06-02-01	<i>JD</i>	<i>JD</i> 06-02-01

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 25395C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

ml 06/02/03 (20)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2322

SB 06/02/06 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ja 02-06 20

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/06 20

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ja 02-08 20

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/02/03 (20)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

LD 06/02/04

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>25395C</i>
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Prototype

[illegible]

Measured by:	J.L	Audited by:	En	Prototype Approval:	N/A
Date:	06-02-01	Date:	06-02-01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	

DART



DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2322	REV. C SHEET 1 OF 1
DATE 98.09.29	TITLE STEP SPACER		
A		94.10.14	NEW ISSUE
C		98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001

RELEASED
18.10.98 DS

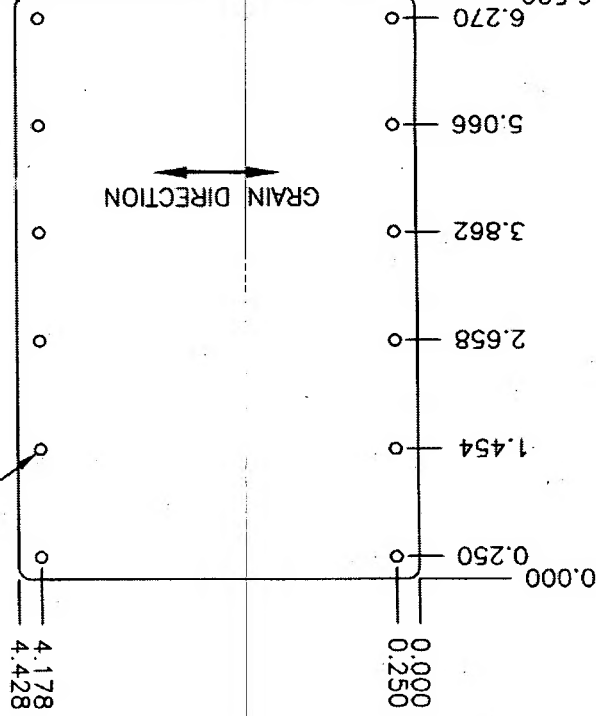
UNDER REVIEW

01.03.15 GP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE
OK GP 04.11.9

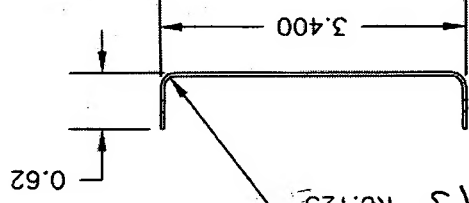


Ø0.128 (TYP 12 PLACES)

Ø0.125 (TYP 4 PLACES)



FLAT LAYOUT



CONTROLLED BY
ENGINEER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
25395C

MATERIAL: 2024-T3 (00-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED